

Work Order ID 92107

Tuesday, October 23, 2012 4:08:43 PM

92107

Page 1

Item ID: PB67-43001-51

Accept

N9000040100

Setup Start ***NS1***

Revision ID:

Item Name: Long T-Handle Assembly

Stop ***NS2***

Start Date: 10/23/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 11/2/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: MLS

Date: 12-10-25 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

B67-43001-51

C

100

Weld per dwg A/R Aluminum rod Batch: 122358 0.00

100

Large Fab

Memo

0.00

Large Fab

1- drill #40 hole in center of -91 before welding -93 caps, to let air out
2- weld -93 to -91 as per dwg
3- grind weld flush
4- assemble -87 under the pilot hole in -91 and weld as per dwg

4 4 12.11.22

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00

110

QC

Memo

0.00

Quality Control

(u) 12-11-23

DAS
09
-88

120

QC5- Inspect part completeness to step on W/O 0.00

120

QC

Memo

0.00

Quality Control

(u) 12-11-23

DAS
09
-88

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											
FAULT CATEGORY											
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Work Order ID 92107

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92107

Page 2

Item ID: PB67-43001-51

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Long T-Handle Assembly

Stop ***NS2***

Start Date: 10/23/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 11/2/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Small Fab					4	0		Ac 12/11/26
Small Fab	Memo	0.00							
Small Fab	1- line drill -89 and -87 using existing pilot hole of -87 as per dwg 2- install spring pin								
140		0.00							
140	QC5- Inspect part completeness to step on W/O	0.00				4			
QC	Memo	0.00							
Quality Control									
150		0.00							
150	Green Sandtex(Ref:4.3.5.8) per QSI005 4.3	0.00				4X	0		mf 12/11/27
Powdercoat	Memo	0.00							
Powder Coating	***mask prior to powder coat per dwg*** START TIME: 3:30 OVEN TEMPERATURE: 320 F FINISH TIME: 4:00								

W18144

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
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Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
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Work Order ID 92107

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92107

Page 3

Item ID: PB67-43001-51 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Long T-Handle Assembly
 Start Date: 10/23/2012 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 11/2/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: <i>SL209A</i>	0.00							
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

4 φ 12-11-28 

4X *SP*
12-11-27

12/11/28 *MF*
12-11-28

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
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Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
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FAULT CATEGORY				
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

Picklist Print

Tuesday, October 23, 2012 4:08:43 PM

Page 1

Work Order ID: 92107

Parent Item: PB67-43001-51

Parent Item Name: Long T-Handle Assembly

Start Date: 10/23/2012

Required Date: 11/2/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 08-07-25 new issue DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
PB67-43001-87 Tube Arm		Manufactured	No			100	Each	4.0000	1	4		12/11/21	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST209a		4							
				53245	→	4							
PB67-43001-91 Tube Handle		Manufactured	No			100	Each	7.0000	1	4		12/11/21	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST444		7							
				41519	→	7							
PB67-43001-93 Tube End Cap		Manufactured	No			100	Each	22.0000	2	8		12/11/21	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST445		22							
				41520	→	22							
240-107 SPRING SLOTTED PIN		Purchased	No			130	Each	159.0000	1	4		12/11/21	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				122089	→	81							
				122089		81							
				ST400		78							
				115827		78							
PB67-43001-89 Clevis		Manufactured	No			130	Each	8.0000	1	4		12/11/21	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST444		8							
				23986	→	7							
				40073		1							

NCR: Yes / No

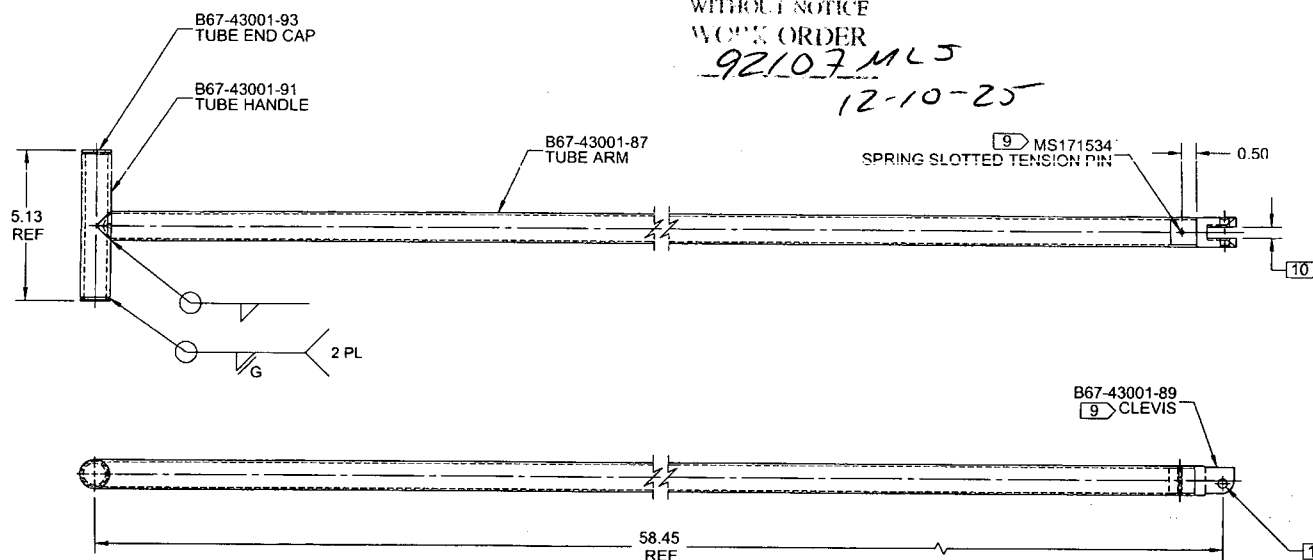
WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>						
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ITEM	QTY -19	P/N	DESCRIPTION
1	X	B67-43001-51	LONG T-HANDLE ASSY
3	1	B67-43001-87	TUBE ARM
4	1	B67-43001-89	CLEVIS
5	1	B67-43001-91	TUBE HANDLE
6	2	B67-43001-93	TUBE END CAP
8	1	MS171534	SPRING SLOTTED TENSION PIN (OR 240107)



B67-43001-51 LONG T-HANDLE ASSY

RELEASED
2009-09-24

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GREEN SANDEX (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.35 lbs
- 8) WELDING: PER QSI 004
- 9) PRIOR TO POWDER COAT, ALIGN B67-43001-89 ON B67-43001-87 AS SHOWN AND DRILL A $\varnothing 0.129$ HOLE THROUGH BOTH PARTS AND FASTEN B67-43001-89 TO B67-43001-87 USING MS171534 SPRING SLOTTED PIN
- 10) MASK PRIOR TO POWDER COAT

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 13 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	09.06.25
REV	DESCRIPTION		BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN				
CHECKED	ADS	DRAWING NO. B67-43001-51	REV. 0	
MFG. APPR.				SHEET 1 OF 1
APPROVED	ADS	TITLE		SCALE
DE APPR.	N/A	LONG T-HANDLE ASSY		NT
DATE	09.06.25	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS LOANED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER OR BY ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **B67-43001-51** REV. C
SHEET 1 OF 1

TITLE **LONG T-HANDLE ASSY** SCALE NTS

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